

Work Order ID 72116

Tuesday, July 19, 2011 11:44:15 AM



Page 1

Item ID: D4016-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Half, Lid

Start Date: 7/19/2011 Start Qty: 18.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 18.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

11-07-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4016

A

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK as per folio

B.R. 11/07/26 18

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA874 AND DWG

FOLIO REV: *AA*

DWG REV: *A*

DEBURR

B.A 11/07/28

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72116

Tuesday, July 19, 2011 11:44:15 AM



Item ID:	D4016-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Hinge Half, Lid					
Start Date:	7/19/2011	Start Qty:	18.00		Cust Item ID:	
Required Date:	7/25/2011	Req'd Qty:	18.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		B-A	11/07/28	18	0		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		smk	11/08/02	18	0		
160 Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00							11/8/35 (180)

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Page 3

Item ID: D4016-3

Accept



Setup Start



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Stop



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Start Date: 7/19/2011 Start Qty: 18.00



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Required Date: 7/25/2011 Req'd Qty: 18.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/04

11-08-2
FS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 11:44:06 AM

Page 1

Work Order ID: 72116

Parent Item: D4016-3

Parent Item Name: Hinge Half, Lid



Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 18.00

Required Qty: 18.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304B1.000X1.000

Purchased

No

100

f

7.5986

0.08

1.515789



304 bar 1.00 x 1.00



F.K. 11/07/26

Location

Loc Qty

Loc Code

MAT050

7.5986

113290

1.047

117130

6.5516

1.52

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD		Work Order:	72116
Description: Hinge Half, Lid		Part Number:	D4016-3
Inspection Dwg: D4016 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	0.876	✓		Vern	GA-01
0.13	+/-0.030	0.125	✓		"	"
0.250	+/-0.010	0.251	✓		"	"
R0.03	+/-0.030	R0.030	✓		"	"
0.13	+/-0.030	0.126	✓		"	"
0.50	+/-0.030	0.499	✓		"	"
0.63	+/-0.030	0.625	✓		"	"
0.563	+/-0.010	0.562	✓		"	"
Ø0.257	+0.006/-0.001	Ø0.258	✓		"	"

Measured by: J.A.	Audited by: [Signature]	Preliminary Approval:
Date: 11/07/28	Date: 11/08/02	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ [Signature]	[Signature]

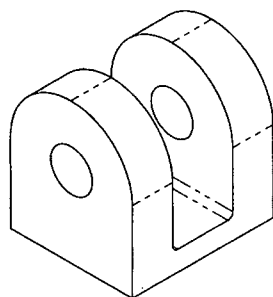
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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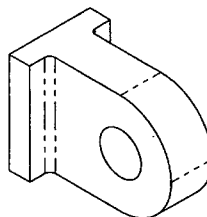
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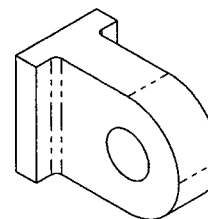
NOTE: Date & initial all entries



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72116

M11-07-10

RELEASED
2010-02-16
MP

A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>RS</i>	D4016	SHEET 1 OF 2
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	BASKET HINGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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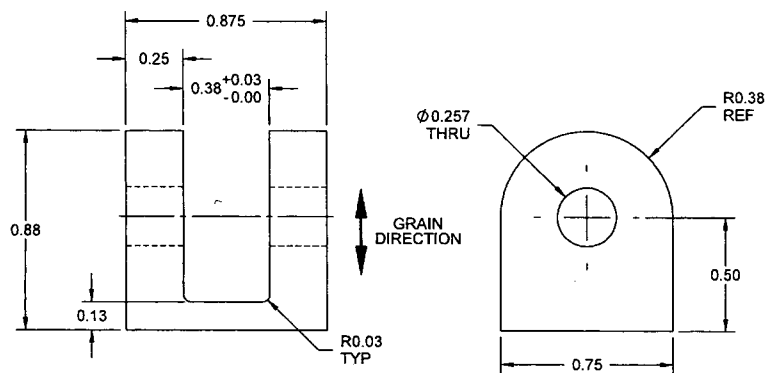
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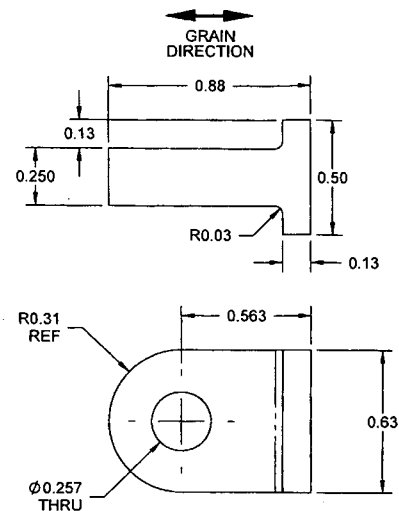
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D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

RELEASED
2010-02-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RP	DRAWING NO.	REV. A
MFG. APPR.	RP	D4016	SHEET 2 OF 2
APPROVED	RP	TITLE	SCALE
DE APPR.	RP	BASKET HINGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND IS CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATIONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Dart Aerospace Ltd

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